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D3065-1

Job Sheet 182281



Part No: D3065-1

Job Qty: 40 ea

Part Name: Step Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/21/18

Job Tracking No:

Due Date: 9/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP: C 02.11.01 Incorporated D3066-1 IPP KJ/RF IPP:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea	9/7/18	9/7/18	0.00	0.00	Start Up Waterjet		De 18/08/27
100	Waterjet	40 pcs	9/7/18	9/7/18	0.00	1.41	Waterjet1		De 18/08/27
120	QC	40 pcs	9/7/18	9/7/18	0.00	0.00	QC8		38
132	Brake NC	40 pcs	9/7/18	9/7/18	0.02	1.07	Brake NC 2		9-89 DAS
150	QC	40 pcs	9/7/18	9/7/18	0.00	0.00	QC5		38
160	HandFinish	40 pcs	9/7/18	9/7/18	0.00	0.58	HandFinish1		SA 18-08-27
161	QC	40 pcs	9/7/18	9/7/18	0.00	0.00	QC7-1		
180	Packaging	40 pcs	9/7/18	9/7/18	0.00	0.00	Packaging3-1		
190	QC21-SA	40 Ea	9/7/18	9/7/18	0.00	0.00	QC21		
Part Op 100 - 1-Cut as per Dwg D3065									DAS 21
Descriptions: 180 - LOCATION : GA									9-89 AUG 28 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.040	2024-T3 .040 Sheet	4.9520 sf (.1238 ea)	90-Start up Operation	2056939

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.040	5	87	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Step Spacer	0.250inches $\pm$ 0.010	0.260 0.240		
2	Step Spacer	2.093inches $\pm$ 0.010	2.103 2.083		
3	Step Spacer	3.936inches $\pm$ 0.010	3.946 3.926		
4	Step Spacer	4.186inches $\pm$ 0.010	4.196 4.176		
5	Step Spacer	0.587inches $\pm$ 0.010	0.597 0.577		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐	AGAINST DEPARTMENT/PROCESS			
Part No. _____		Skid-tube Machining ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
NCR No. _____		Forming ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
			Finishing ☐	Rec/Store/Packaging ☐	Other ☐
			Composite ☐	Supplier ☐	

Date : _____ Step #: _____

MRB (QSI042) Approval

Description Work Order

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval



Root Cause		Fault Category	
Environment ☐	No Re-verification ☐	Pressure/Force ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐		
Misidentified ☐	Past Due ☐	OTHER : _____	

6	Step Spacer	0.128inches + 0.005 - 0.001	0.133 0.127
7	Step Spacer	0.125inches $\pm$ 0.010	0.135 0.115
8	Step Spacer	3.465inches $\pm$ 0.010	3.475 3.455
9	Step Spacer	1.250inches + 0.012 - 0.001	1.262 1.249
10	Step Spacer	0.368inches $\pm$ 0.010	0.378 0.358
11	Step Spacer	0.871inches $\pm$ 0.005	0.876 0.866
12	Step Spacer	0.040inches $\pm$ 0.010	0.050 0.030

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐																			